

Work Order ID 72584

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Tuesday, August 02, 2011 2:38:44 PM

Item ID: D2891-1

Accept



Setup Start



Revision ID:

Stop



Item Name: 2.25 Support

Start Date: 8/2/2011 Start Qty: 9.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 9.00



Customer:

Reference: ECN11-615

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2891

Rev A U/R

ECN11-615



0.00

0.00

85 11-08-12 (x7)

135



SprayPaint

Memo

Spray Painting

PULL FROM STOCK:
X D2891-1 B70734

FOR THE ENTIRE INNER CONCAVE SURFACE:
~ ABRASE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE
WITH MEK
(OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M
SCOTCH-WELD 2216 BfA
ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR
24 HOURS.

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

(7) 11-08-15

Work Order ID 72584



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Item ID:	D2891-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	2.25 Support					
Start Date:	8/2/2011	Start Qty:	9.00			
Required Date:	8/2/2011	Req'd Qty:	9.00			
Reference:	ECN11-615					
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>X tube</i>	0.00							
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

85 11-08-15

11/8/15
MF
11-08-15

Picklist Print

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Work Order ID: 72584



Parent Item: D2891-1



Parent Item Name: 2.25 Support

Start Date: 8/2/2011

Required Date: 8/2/2011

Start Qty: 9.00

Required Qty: 9.00

Comments:

IPP C 02.11.26 Added P/O KJ

IPP D 08.03.19 Re-format EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2891-1

Manufactured

No

Each

0.0000



2.25 Support

#

RT

11-08-12

74 70734

List Lots

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Criteria : Item ID: d2891-1 All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID				Lot Code		
D2891-1	Main Warehouse	70734	7/28/2011	9.0000	QC21		
2.25 Support	LG052						
Total:				9.0000			

72584

W

STCruz
Bun 2/20/16

NOTES:

1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ± 0.010) UNLESS OTHERWISE NOTED

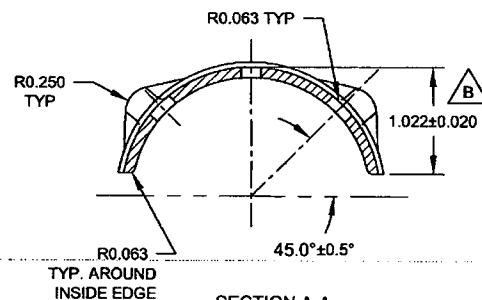
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

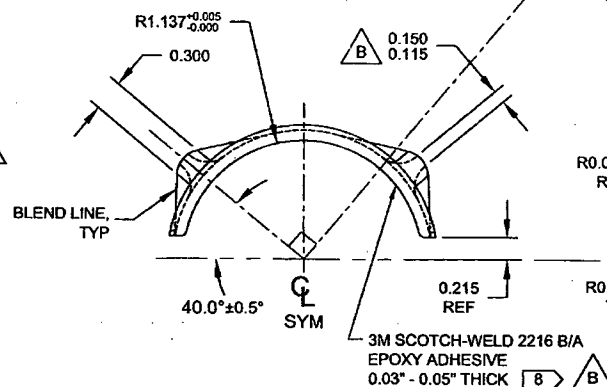
6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.

7) WEIGHT: 0.38 lb

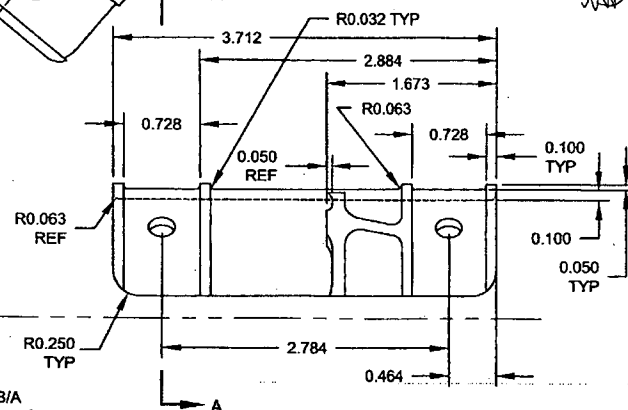
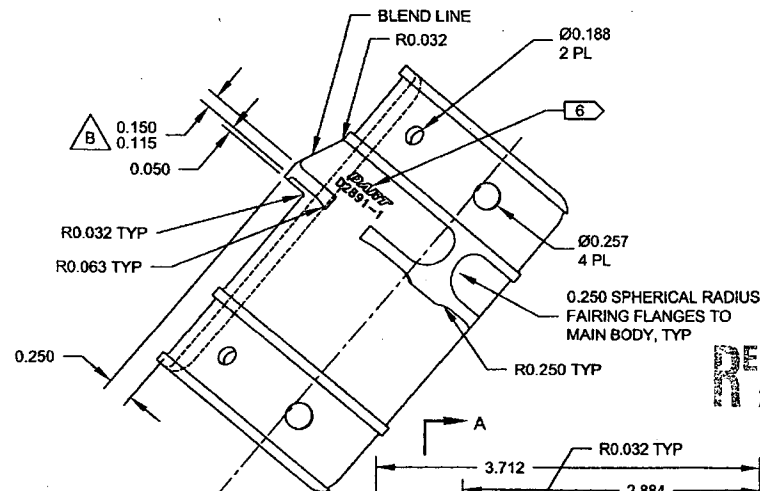
8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



SECTION A-A



D2891-1 SUPPORT



B	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION, UPDATE TOLERANCE (ZN D4-1,B4-1,B6-1)	CP	11.07.15
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D2891	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		Ø2.250 SUPPORT	NTS
DATE	11.07.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2011-07-28

72584